

Sh. of 17/10 SPLIT

Date: Thursday, 10/11/2007 2:54:04 PM
User: Kim Johnston

Process Sheet

(SHORT)

Customer: CU-DAR001 Dart Helicopters Services
 Job Number: 35117
 Estimate Number: 10050
 P.O. Number: N/A
 This Issue: 10/11/2007 S.O. No.: N/A
 Prsh Rev.: NC
 First Issue: N/A
 Previous Run: 31245
 Written By: 10/10/11
 Checked & Approved By: 10/10/11
 Comment: Est. D 01.08.28 Added Powder coat, and added Inspection level 3 and 21. SM

Drawing Name: STRUT
 Part Number: D2565207
 Drawing Number: D2565 REV E
 Project Number: N/A
 Drawing Revision: E
 Material: N/A
 Due Date: 10/17/2007
 Qty: 10 Ums: Each

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description: | |
|---------|-----------------------|--|-------------|
| 1.0 | MS04TR0750W049 | 304 RD Tube .750 x .049W | |
| | | Comment: Qty: 1.8812 f(s)/Unit Total: 18.8118 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304-TR0750W049) Batch No: M105732 | SB 27/10/15 |
| 2.0 | BRAKE NC | NC BRAKE | |
| | | Comment: BRAKE NC Punch: as per Dwg D2565 using DT 8313 | SB 27/10/15 |
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 | SB 27/10/15 |
| | Deburr and polish | | SB 27/10/15 |
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP | |
| | | Comment: INSPECT WORK TO CURRENT STEP | SB 27/10/16 |
| 5.0 | POWDER COATING | POWDER COATING | |
| | | Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 | SB 09-10-17 |

Date: Thursday, 10/11/2007 2:54:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 35117

Part Number: D2565207

Job Number:



Seq. #: Machine Or Operation:

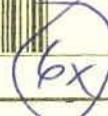
Description:

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



1/10/07 SP



Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



1/10/07

SP



Comment: PACKAGING RESOURCE #1

Identify and Stock:

Location: _____

8.0 QC21

FINAL INSPECTION/W/O RELEASE



1/10/07

SP

Comment: FINAL INSPECTION/W/O RELEASE

1/10/07

Job Completion



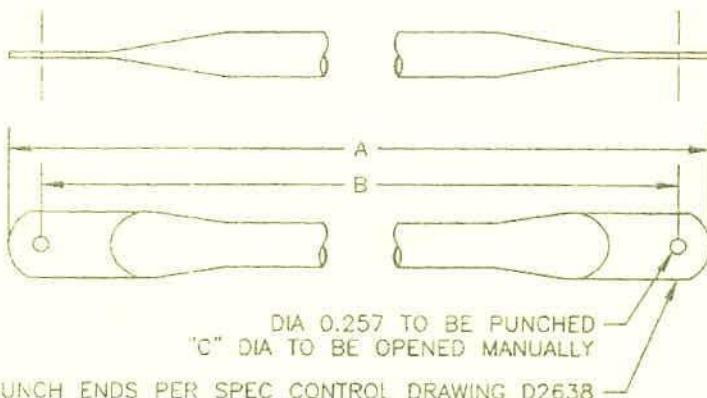
u 1/10/07

DART

| | | | | |
|----------|----------|---|--------|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | APPROVED | DRAWING NO. | REV. E | |
| | | D2565 | | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE | |
| 04.05.05 | | STRUT | 1:3 | |
| A | 96.05.03 | NEW ISSUE | | |
| B | 97.03.15 | CORRECT D2565-111 DIM. A | | |
| C | 98.10.05 | UPDATED MATERIAL NOTE (TSR A303) | | |
| D | 02.06.05 | ADD -3XX PARTS; ADD FINISH | | |
| E | 04.05.05 | ADD D2565-401-411; RMV ANGLE D | | |

RELEASED

04.05.05



| PART # | A | B | DIA | C |
|-----------|-------|-------|-------|---|
| D2565-101 | 20.52 | 19.72 | 0.316 | |
| D2565-103 | 18.21 | 17.41 | 0.316 | |
| D2565-105 | 20.19 | 19.39 | 0.316 | |
| D2565-107 | 13.43 | 12.63 | — | |
| D2565-109 | 12.31 | 11.51 | — | |
| D2565-111 | 13.65 | 12.85 | — | |
| | | | | |
| D2565-201 | 22.79 | 22.00 | 0.316 | |
| D2565-203 | 20.75 | 19.95 | 0.316 | |
| D2565-205 | 21.22 | 20.42 | 0.316 | |
| D2565-207 | 16.07 | 15.27 | — | |
| D2565-209 | 15.16 | 14.36 | — | |
| D2565-211 | 14.14 | 13.34 | — | |
| | | | | |
| D2565-301 | 27.03 | 26.23 | 0.316 | |
| D2565-303 | 25.34 | 24.54 | 0.316 | |
| D2565-305 | 23.73 | 22.93 | 0.316 | |
| D2565-307 | 20.86 | 20.06 | — | |
| D2565-309 | 20.17 | 19.37 | — | |
| D2565-311 | 16.30 | 15.50 | — | |
| | | | | |
| D2565-401 | 18.29 | 17.49 | 0.316 | |
| D2565-403 | 15.64 | 14.84 | 0.316 | |
| D2565-405 | 19.45 | 18.65 | 0.316 | |
| D2565-407 | 10.79 | 9.99 | — | |
| D2565-409 | 9.34 | 8.54 | — | |
| D2565-411 | 13.81 | 13.01 | — | |

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN

ENGINEER

UNCONTROLLED

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK

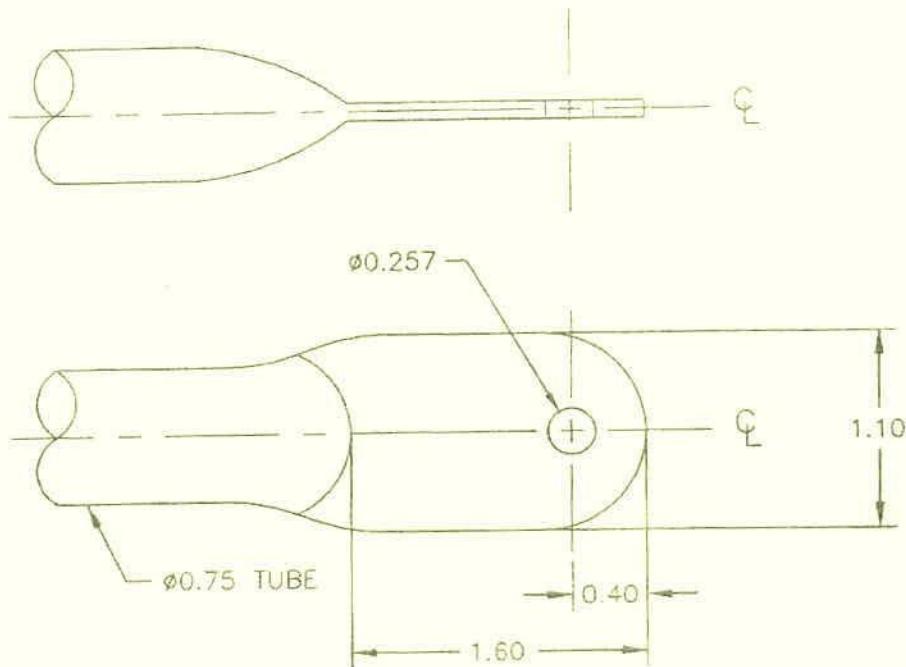
NO. 35717



| | | | |
|------------------|------------------------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED NO | APPROVED F | DRAWING NO. D2638 | REV. A SHEET 1 OF 1 |
| DATE 98.04.28 | TITLE PUNCH DT8117 SPEC CONTROL | | SCALE 1:1 |
| A | 98.04.28 | NEW ISSUE | |

RELEASED
1998.04.28 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



SEARCHED
INDEXED
FILED
ENGINEERED
UNCONTRIBUTED
SUBJECT TO EXAMINER
WITHOUT CREDIT
WORK NO. 35117

